

Work Order ID 68384

Tuesday, April 12, 2011 1:25:19 PM



Page 1

Item ID:	D3255-042	Accept		Setup	Start	
Revision ID:					Stop	
Item Name:	Access Panel Assembly					
Start Date:	4/12/2011	Start Qty:	4.00		Cust Item ID:	
Required Date:	4/15/2011	Req'd Qty:	4.00		Customer:	
Reference:						

Approvals:	Process Plan:		Date:	4/04/12	Tooling:		Date:		Run	Start	
	QC:		Date:		SPC (Y/N):		Date:			Stop	

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
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Draw Nbr	Revision Nbr								
D3255	Rev B								

100		0.00							
	Large Fab								
Large Fab	Memo	0.00							
Large Fab	1-Weld as per Dwg D3255 ***purge weld*** <input type="checkbox"/> A/R SS ROD								
	Batch: <u>1114049</u> <input type="checkbox"/> 2-Grind Welds Flush								

11-04-13 (4x)

110	QC10- Inspect visual per QSI004- ground welds	0.00							
QC	Memo	0.00							
Quality Control									

11-04-14

120	QC5- Inspect part completeness to step on W/O	0.00							
QC	Memo	0.00							
Quality Control									

11 04 14 (4)

W/O:		WORK ORDER CHANGES					
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Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

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DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
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NOTE: Date & initial all-entries

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Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
130 	Grey Sandtex(Ref:4.3.5.6) per QSI005 4.3	0.00							
Powdercoat	<i>M 115128.</i>	0.00				<i>4</i>	<i>PL</i>	<i>11-4-15.</i>	
Powder Coating	Memo								
	START TIME: <i>10:00</i> □ OVEN TEMPERATURE:								
	<i>3:20</i> □ FINISH TIME: <i>10:30</i>								
140 	QC3- Inspect Part Finish	0.00							
QC	Memo	0.00				<i>4</i>	<i>d</i>	<i>11/4/15</i>	
Quality Control									
150 	Small Fab	0.00							
Small Fab	Memo	0.00				<i>(4)</i>			
Small Fab	1-Bond D3255-5 gasaket to d3255-042 using Dow corning adhesive as per Dwg								
	D3255 □ A/R 736 DOW CORNING ADHESIVE								
	Batch: <i>M116664</i>								

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Reference:						

Approvals:	Process Plan:	Date:	Tooling:	Date:	Run	Start	
	QC:	Date:	SPC (Y/N):	Date:		Stop	

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
160 QC Quality Control	QC5- Inspect part completeness to step on W/O Memo	0.00 0.00							
170 Packaging Packaging	Identify as per dwg & Stock Location: Memo	0.00 0.00							
180 QC Quality Control	QC21- Final Inspection - Work Order Release Memo	0.00 0.00							

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NOTE: Date & initial all entries

Picklist Print

Tuesday, April 12, 2011 1:25:27 PM

Page 1

Work Order ID: 68384

Parent Item: D3255-042

Parent Item Name: Access Panel Assembly



Start Date: 4/12/2011


Required Date: 4/15/2011

Start Qty: 4.00

Required Qty: 4.00


Comments: IPP Rev:C Removed Manufacturing of D3255-1/-2/-3 06-08-02 JLM

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
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✓ D3255-2  Panel		Manufactured	No			100	Each	5.0000	1	4			
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Location Loc Qty Loc Code

WA025 5
61686 1
66575 4

D3255-5  Gasket		Manufactured	No			100	Each	10.0000	1	4			
--	--	--------------	----	--	--	-----	------	---------	---	---	--	--	--

Location Loc Qty Loc Code

GA 10
63588 2
66574 8

✓ D3255-3  Cap		Manufactured	No			150	Each	21.0000	1	4			
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Location Loc Qty Loc Code

WA021 21
66812 21

Handwritten signature and date: 11-04-13

Handwritten circled number 4

Handwritten signature and date: 11-04-13

Handwritten circled number 4

Handwritten circled number 4

Handwritten signature and date: 11-04-13

Handwritten circled number 4

W/O:		WORK ORDER CHANGES					
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Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

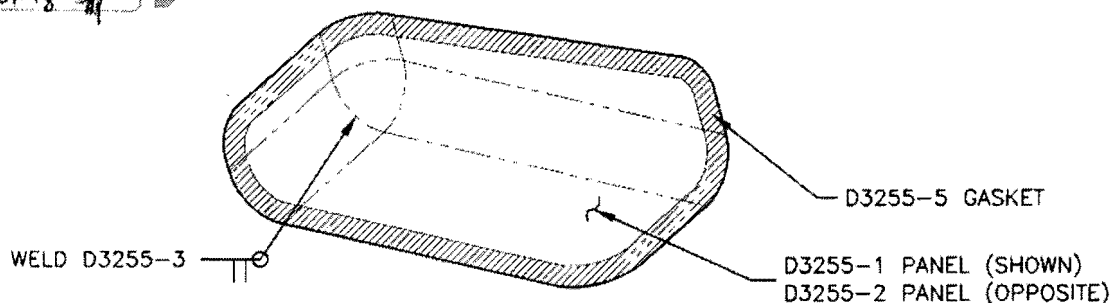
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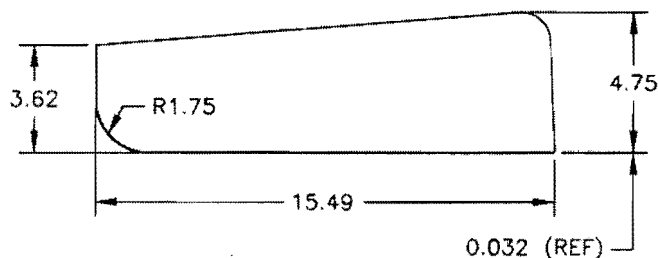
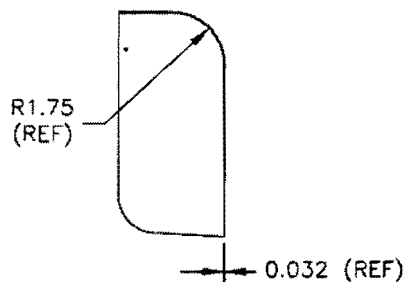
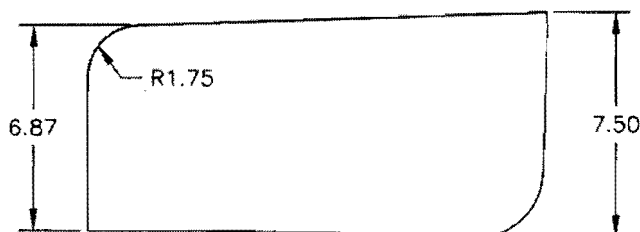


DESIGN [Signature]	DRAWN BY [Signature]	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
CHECKED [Signature]	APPROVED [Signature]	DRAWING NO. D3255	REV. B SHEET 1 OF 4
DATE 04.12.06		TITLE ACCESS PANEL ASSEMBLY	SCALE 1:6
A	04.01.27	NEW ISSUE	
B	04.12.06	D3255-3 REDESIGN; ADDED $\phi 0.098$	

RELEASED
05-01-18 #



D3255-041 ACCESS PANEL (SHOWN)
D3255-042 ACCESS PANEL (OPPOSITE)



D3255-1 BEND DETAIL
D3255-2 OPPOSITE

SHOP COPY
RETURN TO
ENGINEERING
UNCONTROLLED COPY
SUBJECT TO AMENDMENT
WITHOUT NOTICE
WORK ORDER
NO. 68384

PL 11-04-12

D3255-041/-042 NOTES:

- 1) WELD PER DART QSI 004
- 2) FINISH: POWDER COAT GREY SANDTEX (4.3.5.6) PER QSI 005 4.3
- 3) INSTALL D3255-5 GASKET USING DOW CORNING P/N 736 ADHESIVE IN ACCORDANCE WITH MANUFACTURE'S INSTRUCTIONS
- 4) IDENTIFY WITH P/N & B/N USING FINE POINT PERMANENT MARKER

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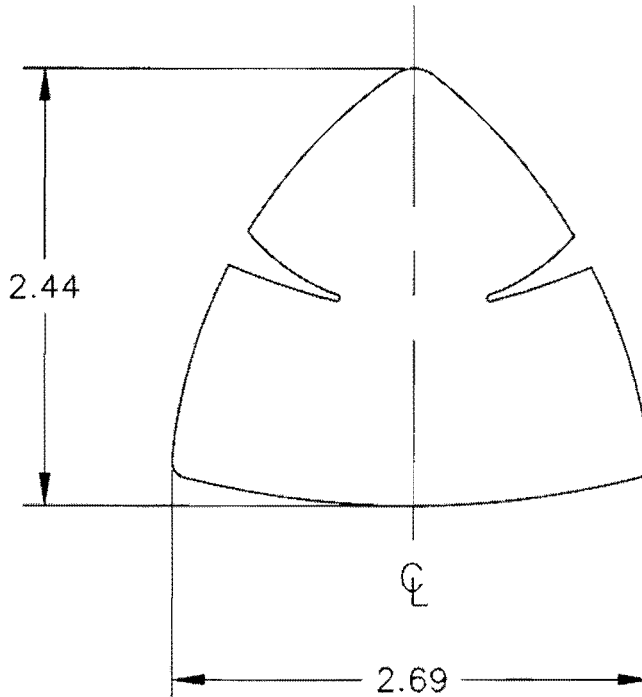
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NOTE: Date & initial all entries



DESIGN JF	DRAWN BY JF	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
CHECKED JP	APPROVED [Signature]	DRAWING NO. D3255	REV. B SHEET 2 OF 4
DATE 04.12.06		TITLE TITLE	SCALE 1:1

RELEASED
05.01.08 [Signature]



w/o 68384

D3255-3 CAP
FORM TO FIT D3155-1/-2

D3255-3 NOTES:

- 1) MATERIAL: AISI 304/316 SS 0.032 THICK (REF. M304S22GA)
- 2) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 3) ALL DIMENSIONS ARE IN INCHES
- 5) BREAK ALL SHARP EDGES 0.005 TO 0.010
- 6) MAKE PER DRAWING "D3255-B2.DWG"

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Dart Aerospace Ltd

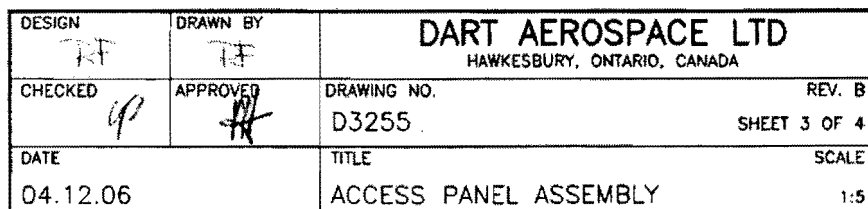
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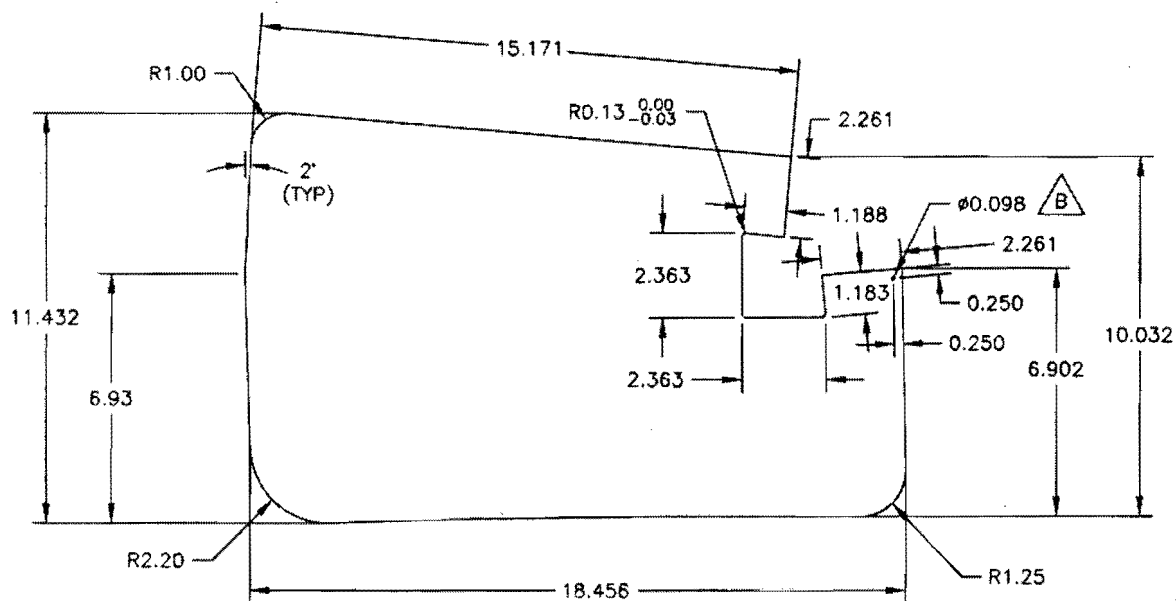
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NOTE: Date & initial all entries



RELEASED
05-01-18

W/O 48384



D3255-1/-2 FLAT PATTERN

D3255-1/-2 NOTES:

- 1) MATERIAL: AISI 304/316 SS 0.032 THICK (REF. M304S22GA)
2) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
3) ALL DIMENSIONS ARE IN INCHES
4) BREAK ALL SHARP EDGES 0.005 TO 0.010

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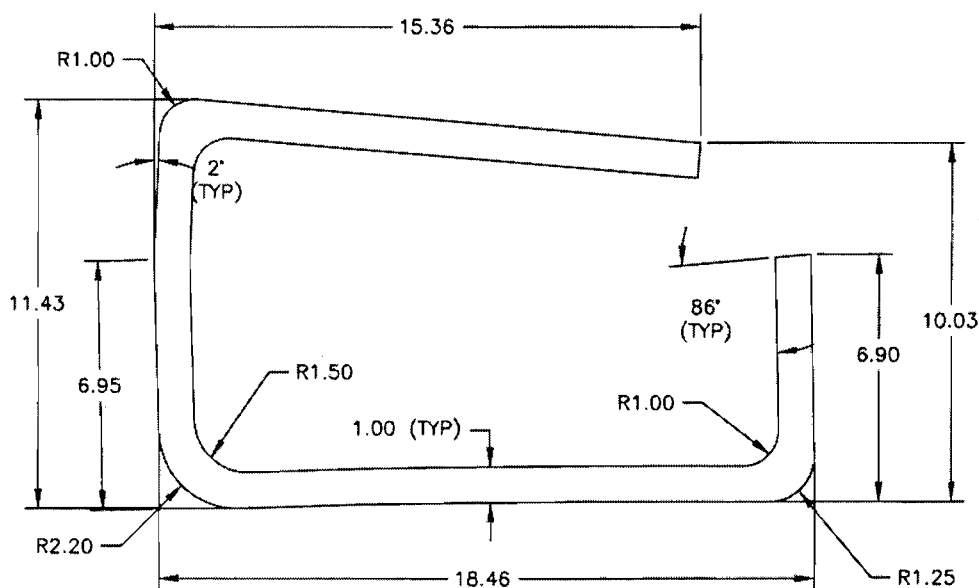
NOTE: Date & initial all entries



DESIGN JF	DRAWN BY JF	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
CHECKED ip	APPROVED JF	DRAWING NO. D3255	REV. B SHEET 4 OF 4
DATE 04.12.06		TITLE ACCESS PANEL ASSEMBLY	SCALE 1:5

RELEASED
DS 01.18 #

u/048384



D3255-5 GASKET

D3255-5 NOTES:

- 1) MATERIAL: SILICONE COATED FIBERGLASS CLOTH PER AMS 3320F
P/N SIL/F 36x36x1/16
POSSIBLE SUPPLIER: AVIALL
- 2) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 3) ALL DIMENSIONS ARE IN INCHES

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